

Date: Friday, 11/18/2005 5:31:36 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 24878		
Estimate Number	: 10299		
P.O. Number	: N/A	Part Number	: D25775
This Issue	: 11/18/2005 S.O. No. : N/A	Drawing Number	: D2577 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: E
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 12/15/2005
Checked & Approved By	: SEE ABOVE USER & DATE	Qty:	50 Um: Each
Comment	: Est: F 02.09.24 Re-format KJ/RF		

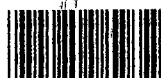
Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 146

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-5

Material release note required

W

05/11/22

50

2.0	D25775F	Wearplate, Centre
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Comment: Qty: 1.0000 U(s) Unit Total: 50.0000 U(s)

WEAR PLATE FWD

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

DL 05/12/30 50

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2577-5T1

06/01/11 50

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

N/A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/03/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/18/2005 5:31:36 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 24878

Part Number: D25775

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

(50)

SB 06/01/19

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Jan-20

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/21

(50)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 03 22

(50)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: f.p

ml 06 03 22 (50)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

LD 06/03/22 (50)

Job Completion



W 06.03.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 18, 2005
09:21 am

Work Order No	:	0024878	Department Code:	
Project Name	:	D2577-5	Burden Flags	: NNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2577-5	Invoice Number	:
Description	:	Wearplate, Centre	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	50	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-18-05		
Est Finish Date	:	12-15-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8956 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Wairuku
Fax: (09) 375 8850

TEST CERTIFICATE

Ref: 5210722493

CUSTOMER	Wilkinson	P50323 DI001	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC112397
CUSTOMER O/N	90-21N-686		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	480737		DIMENSIONS	0.055" x 48" x Coil	DATE	09 June 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)							DATE	09 June 2005
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH		
		x100			x1000										x10000		x100	180°			G.L.°	HRB	()	(feet)		
R9-459713-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1585		
R9-459714-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				54		1457		
R9-459715-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1375		
R9-459716-00	641513	5	TR	18	9	18	12	17	15	1	6	1	1					Good				48		1473		
R9-459717-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1631		
R9-459718-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				48		1093		
R9-459719-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1562		
R9-459720-00	641756	5	TR	20	12	19	12	18	19	1	7	1	1					Good				50		1535		
R9-460380-00	641761	4	TR	20	13	17	12	18	25	5	8	1	1					Good				50		1581		
R9-460381-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1562		
R9-460382-00	641758	4	TR	18	4	16	13	19	10	5	3	1	1					Good				49		1503		
R9-461458-00	642309	2	TR	18	10	20	11	17	19	1	6	1	1					Good				48		1785		

YIELD	GAUGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=80mm (E)=2"	(A)=0 (C)=r45	(A)=5mm x 5mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65? So (F)=8"	(B)=90 (D)=(r0+r90+2r45)/4	(B)=10mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
			(B)=7.5mm x 10mm	(C)=C+Mn/6+Si/24
			(E)=5mm x 10mm	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

16 ga 25 065 146, 267, 245



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8080 / 235 3535 Waiuku
Fax: (09) 375 8950

TEST CERTIFICATE

Ref: 5379/23850

Reissued 22/8/2005

CUSTOMER		Wilkinson		P50505-01002										SPECIFICATION					ASTMA1008 CS Type A					CERTIFICATE No		TC116858	
CUSTOMER ON		98-21N-742												PRODUCT					CRA WIDE COIL					PAGE		1 of 1	
MILL ON		486968												DIMENSIONS					0.033" x 48" x Coil					DATE		19 August 2005	
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)										
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH			
		x100					x1000					x10000					x100		180°				G.L.=	HRB	()	(feet)	
R9-466088-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700			
R9-466081-00	845423	6	TR	21	11	16	17	20	16	2	3	1	3					Good				50		2700			
R9-466082-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651			
R9-466083-00	845253	6	1	21	10	12	28	30	15	2	3	1	3					Good				47		2651			

YIELD	GAUGE LENGTH (G.L.)				PLASTIC STRAIN RATIO (r)				IMPACT TEST				CARBON EQUIVALENT VALUE (CE)			
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"		(A)=0	(C)=r45			(C)=5mm x 5mm				(A)=C+Mn/6			(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 x So	(F)=8"		(B)=90	(D)=(r0+r90+2r45) / 4			(A)=10mm x 10mm	(D)=2.5mm x 10mm			(B)=C+Mn/8+(Cr+V+Mo)/5+(Cu+Ni)/15			(D)=
									(B)=7.5mm x 10mm	(E)=5mm x 10mm						

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WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*
QC METALLURGIST

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PO# 267, 146,

